



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3883-2

Job Sheet 164923



Part No: D3883-2

Job Qty: 10 ea

Part Name: Saddle, Outside RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D3883-2 Saddle, Outside RH	DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD VERF:JLM		0.000	
D6101-015 Saddle Billet	DWG REV B IPP RevA: New issue DD verified by:EC		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	10 Ea	10/27/17	0.00	0.00	Start up container	
100	CNC Vertical Machining	10 pcs	10/30/17	0.64	22.73	HAAS 1	
110	QC	10 pcs	10/30/17	0.00	0.00	QC1	
120	QC	10 pcs	10/30/17	0.00	0.00	QC8	
130	HandFinish	10 pcs	10/30/17	0.00	1.02	HandFinish1	2017/10/30 JSL
140	Powdercoat	10 pcs	10/31/17	0.00	0.38	Powdercoat1	DAS
150	QC	10 pcs	10/31/17	0.00	0.00	QC3	38
160	Packaging	10 pcs	10/31/17	0.00	0.00	Packaging3	57404 9-88
170	QC21-SA	10 Ea	10/31/17	0.00	0.00	QC21	9-89

Part Op 100 - Program Batch No SDD181 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets

110 - Inspect on CMM as per folio CMM013.

140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)***

M 138014 START: 12:00 OUT: 3:20 FINISH: 12:30.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-015	F162154 (10) F165286 (30)	0	0	0

Part Specifications

Specifications could not be found.

08-9

DART AEROSPACE

S001181



Saddle, Outside RH

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:

Revision:

Operation:

Quantity:

Change No:

D3883-2

Start up Operation
10

Mfg Date: 10/21/17
Job No: 164923

Work Order ID 164923

164923

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Wednesday, August 09, 2017

Item ID: D3883-2

Revision ID:

Item Name: Saddle, Out

Start Date: 9/28/2017

Required Date: 10/4/2017

Reference:

Approvals: Process

QC:

Sequence ID/
Work Center ID

Draw Nbr

D3883

D

100

100

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

6.90

Program Batch No. _____

Double check by: _____

1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets

110

110

QC

Quality Control

QC1- Inspection performed by CMM

0.00

Memo

0.10

Inspect on CMM as per folio CMMA013.

DWG REV: _____

CMM PROG. REV: _____

10000040100

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------	-----------	------------	------------	---------------	-------------

D6101-015 → 6 blanks
Short

2 04 3 semaine
from 17-08-18 Lr

10 _____ SBLol 17/10/25

10 _____ SBLol 17/10/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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164.923

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/28/2017 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 10/4/2017 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.20

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

1.27

Hand Finishing

(10) ✓ 2017/10/30 JSC

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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164923

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

Start Date: 9/28/2017 **Start Qty:** 10.00

10

Customer:

Required Date: 10/4/2017 **Req'd Qty:** 10.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

Identify as per dwg & Stock Location:_____

0.00

160

Packaging

Memo

0.10

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

1.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 164923

164923

Parent Item: D3883-2

D3883-2

Parent Item Name: Saddle, Outside RH

Start Date: 9/28/2017

Required Date: 10/4/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015 *D6101-015* Saddle Billet		Manufactured	No			100	Each	10.0000	1	10			
											**	DAS 44 9-89	17-10-21

Location

Loc Qty

Loc Code

MAT045

10

162154

10

165286

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 164923
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658	.59	.645	.644	.644	.644		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625	.486	.612	.611	.615	.611		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.005	2.005	2.005	2.005		
J	0.140	0.165		.150	.150	.148	.149		
K	0.240	0.260		.250	.250	.247	.249		
L	0.115	0.135		.125	.125	.125	.125		
M	0.140	0.165		.152	.150	.150	.150		
N	0.720	0.780		.775	.770	.770	.770		
O	0.240	0.260		.254	.255	.254	.254		
P	0.110	0.140		.143	.142	.142	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.855	2.855	2.855	2.855		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010	.842	1.000	1.000	1.001	1.001		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510	.4435	.501	.500	.500	.499		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.313	.313	.313	.313		
AB	0.020	0.040		.035	.033	.035	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.218	.218	.218	.217		
AE	1.265	1.285		1.265	1.265	1.266	1.265		
AF									
Accept/Reject									

Measured by: SBL 01
Date: 17/10/25 / 17-10-24

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8	By	Date
A	2.870	2.880		2,875	2,875	2,875	2,875		
B	1.433	1.443		1,438	1,438	1,438	1,438		
C	0.638	0.658	.519	.644	.644	.644	.644		
D	3.895	3.905		3,900	3,900	3,900	3,900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625	.486	.611	.610	.611	.615		
G	1.120	1.130		1,125	1,125	1,125	1,125		
H	2.245	2.255		2,250	2,250	2,250	2,250		
I	2.000	2.020		2,000	2,000	2,000	2,000		
J	0.140	0.165		.150	.149	.151	.150		
K	0.240	0.260		.252	.249	.250	.250		
L	0.115	0.135		.124	.125	.125	.124		
M	0.140	0.165		.150	.152	.152	.152		
N	0.720	0.780		.775	.775	.770	.766		
O	0.240	0.260		.249	.248	.252	.249		
P	0.110	0.140		.125	.127	.130	.130		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2,855	2,855	2,850	2,853		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010	.842	1,000	1,000	.999	.998		
U	1.745	1.755		1,750	1,750	1,750	1,750		
V	5.990	6.010		6,001	6,001	6,001	6,001		
W	1.245	1.255		1,250	1,250	1,250	1,250		
X	0.490	0.510	.3435	.500	.498	.499	.500		
Y	1.220	1.280		1,250	1,250	1,250	1,250		
Z	2.495	2.505		2,500	2,500	2,500	2,500		
AA	0.313	0.318		.313	.313	.313	.313		
AB	0.020	0.040		.035	.035	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.218	.218	.216	.217		
AE	1.265	1.285		1,265	1,265	1,265	1,265		
AF									
Accept/Reject									

Measured by: <u>SBLO/</u>	Audited by:
Date: <u>17/10/25</u>	Date:

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1	

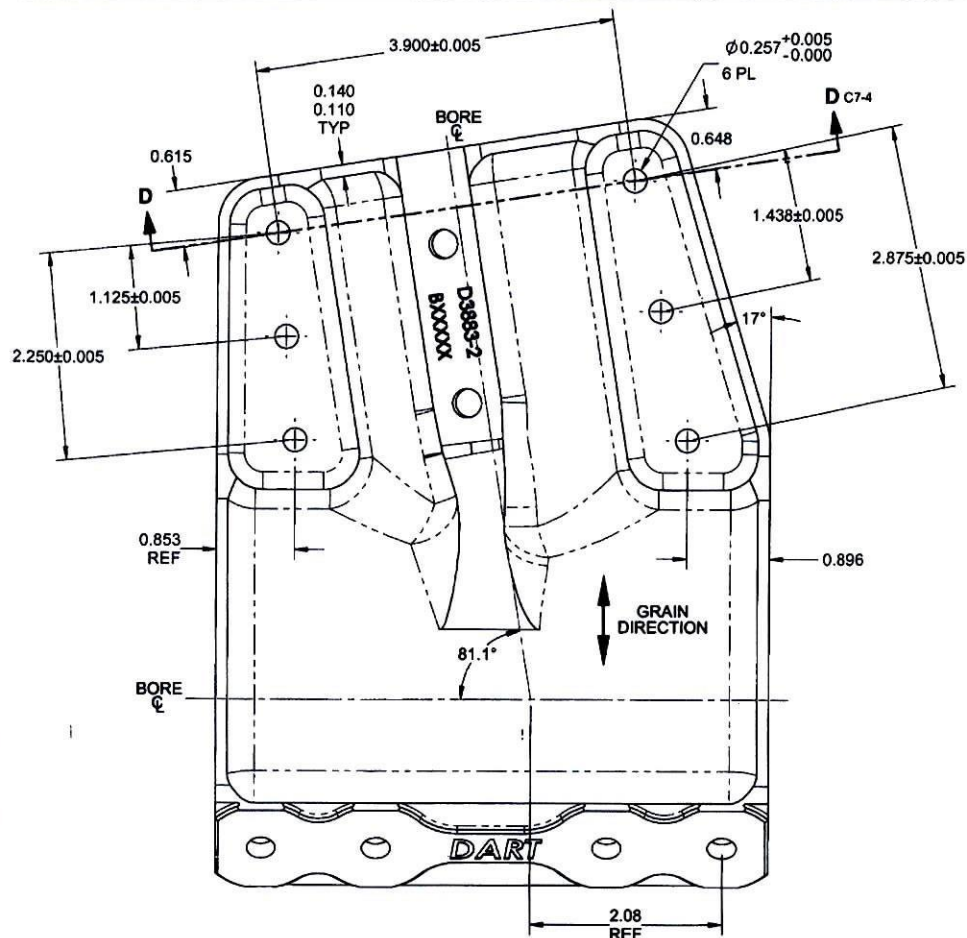
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	3	4		
A	2.870	2.880		2,875	2,875				
B	1.433	1.443		1,438	1,438				
C	0.638	0.658	519	643	644				
D	3.895	3.905		3,900	3,900				
E	0.257	0.262		258	258				
F	0.605	0.625	486	610	612				
G	1.120	1.130		1,125	1,125				
H	2.245	2.255		2,250	2,250				
I	2.000	2.020		2,000	2,000				
J	0.140	0.165		150	150				
K	0.240	0.260		250	251				
L	0.115	0.135		125	124				
M	0.140	0.165		150	151				
N	0.720	0.780		765	765				
O	0.240	0.260		250	249				
P	0.110	0.140		130	130				
Q	0.178	0.198		188	188				
R	2.825	2.885		2,852	2,855				
S	0.316	0.321		316	316				
T	0.990	1.010	842	999	1,000				
U	1.745	1.755		1,750	1,750				
V	5.990	6.010		6,001	6,001				
W	1.245	1.255		1,250	1,250				
X	0.490	0.510	3435	500	498				
Y	1.220	1.280		1,250	1,250				
Z	2.495	2.505		2,500	2,500				
AA	0.313	0.318		313	313				
AB	0.020	0.040		030	030				
AC	0.760	0.765		760	760				
AD	0.215	0.220		217	216				
AE	1.265	1.285		1,265	1,265				
AF									
Accept/Reject									

Measured by:	SBZol
Date:	17/10/25

Audited by:	
Date:	

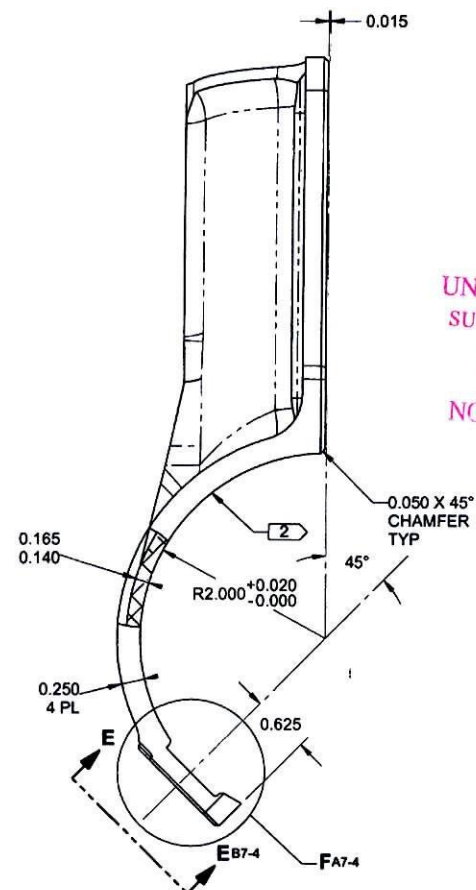
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	



D3883-2 SADDLE, OUTBOARD RH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REVD.SLDPRT"



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RELEASED
APR 2015 MAY 19

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3883	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD SADDLE	NTS
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